

BLUE

# Work Order ID 62116

September 16, 2010 9:22:45 AM



Item ID: D2939-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 9/16/10 Start Qty: 3.00



Cust Item ID:

Required Date: 9/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. 1-1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

*DJP 10/09/20*

3



110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*DJP 10/09/20*

3



120

0.00



QC

QC1-Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

*DJP 10/09/20*

3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62116

September 16, 2010 9:22:46 AM



Page 2

Item ID: D2939-1

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Item Name: Saddle LH In, 206

Start Date: 9/16/10 Start Qty: 3.00



Cust Item ID:

Required Date: 9/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 10/09/21

3 0

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

W 10/09/21

3 0

Memo

0.00

151



SprayPaint

Spray Painting

0.00

0.00

Memo

PRIME B 114424

PAINT DELFLEET BLUE B 115509

CLEAR DELFLEET B 115506

W 10.09.24 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62116

September 16, 2010 9:22:46 AM



Page 3

Item ID: D2939-1

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Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 9/16/10 Start Qty: 3.00



Cust Item ID:

Required Date: 9/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling:

Date:

Stop



QC: Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

161



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

AT 10-09-27 (3)

170



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

P. 10/9/27 (3)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/27

mf

10-9-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 16, 2010 9:22:45 AM

Page 1

Work Order ID: 62116

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206



Start Date: 9/16/10

Required Date: 9/22/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: B: 100.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001

Manufactured

No

100

Each

11.0000

1

3



Saddle Billet



*DJP 10/09/20*

Location

MAT40

Y61385

Loc Qty

11

11

Loc Code

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 6246
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2939-1
<b>Inspection Dwg:</b> D2939 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.123	0.123		118-420	Deep Mic
B	0.100	0.140		0.129	0.128	0.126			"
C	0.100	0.140		0.126	0.127				"
D	0.210	0.230		0.227	0.227	0.227		DSP-02	Mic
E	1.245	1.255		1.250	1.250	1.250		DSP-11	Vern
F	1.245	1.255		1.250	1.250	1.250			"
G	2.495	2.505		2.500	2.500	2.500			"
H	0.510	0.515		0.510	0.510	0.510			"
I	1.572	1.582		1.577	1.577	1.577			"
J	2.495	2.505		2.500	2.500	2.500			"
K	0.257	0.262		0.259	0.259	0.259			"
L	0.312	0.317		0.317	0.317	0.317			"
M	0.235	0.240		0.237	0.237	0.237		DJP-02	Mic
N	0.100	0.140		0.113	0.113	0.113			"
O	0.540	0.560		0.549	0.553	0.553		DSP-11	Vern
P	0.490	0.510		0.498	0.500	0.500			"
Q	3.715	3.725		3.720	3.720	3.720			"
R	2.720	2.760		2.743	2.743	2.743			"
S	0.240	0.270		0.256	0.256	0.2565			"
T	0.100	0.180		0.140	0.140	0.140			"
U	1.625	1.635		1.630	1.630	1.630			"
V	1.362	1.372		1.367	1.367	1.367			"
W	0.316	0.321		0.318	0.318	0.318			"
X	1.250	1.270		1.2595	1.2595	1.260			Dial
Y	1.565	1.585	DT8695 A/B	1.574	1.574	1.5745			"
Z	0.178	0.198		0.188	0.188	0.188			Rad Gage
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

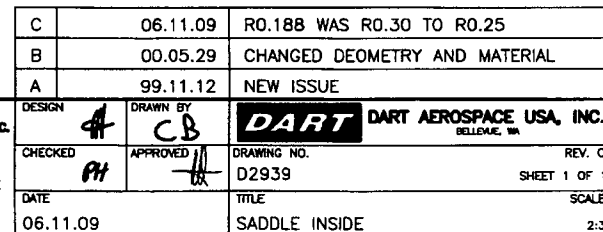
Measured by:
Date: 10/09/20

Audited by: H.A
Date: 10/09/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	




SECTION B-B



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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC.
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CHECKED <b>PH</b>	APPROVED 	DRAWING NO. D2939	REV. C SHEET 1 OF 1
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DATE	TITLE	SCALE
06.11.09	SADDLE INSIDE	2:3

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
3) BREAK ALL SHARP EDGES 0.010 TO 0.020  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE INCHES  
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

07.02.12